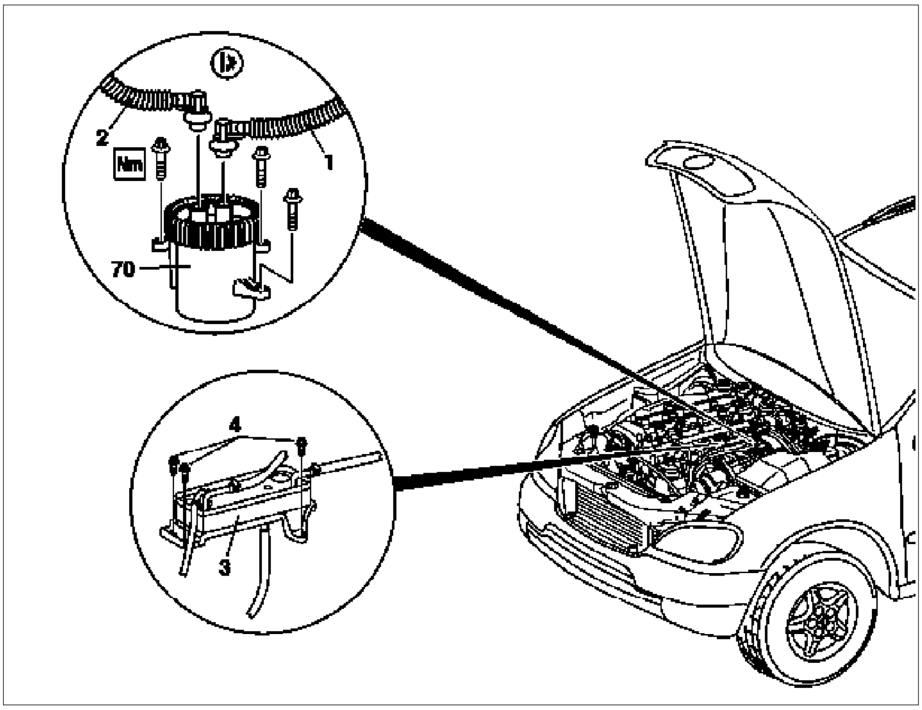
**ENGINE 612.963 in MODEL 163.113**

*1 Fuel feed line*
*2 Fuel return flow line*
*3 Fuel cooler*
*4 Bolts of fuel cooler*
*70 Fuel full-flow filter*




P47.20-2043-06

**Operation no. of operation texts or standard texts and flat rates**

| Sector | Op. no. | Operation text |
|---|---|---|
| P | 075560 | REMOVING AND INSTALLING FUEL FULL-FLOW FILTER |
| P | 075563 | REPLACING FUEL FULL-FLOW FILTER |
| P | 075564 | REPLACING FUEL FULL-FLOW FILTER (AFTER INSPECTING) |

| | **Removing, installing** | | |
|---|---|---|---|
| ⚠ **Danger!** | **Risk of injury** from fingers being **jammed or bruised** when removing or installing and aligning hood, doors, trunk lid/tailgate or sliding roof | Ensure that no parts of your body or limbs are within the operating range when moving such components. | AS00.00-Z-0011-01A |
| ⚠ **Danger!** | **Risk of explosion** as a result of fuel vapors igniting. **Risk of poisoning** as a result of inhaling fuel vapors. **Risk of injury** as a result of fuel coming into contact with skin and eyes. | No fire, naked flame or smoking.<br>Pour fuels only into suitable and appropriate marked containers.<br>Wear protective clothing when handling fuel. | AS47.00-Z-0001-01A |
| 1 | Open hood and raise to vertical position | Have assistant secure hood. | AR88.40-P-1000GI |
| 2 | Remove trim panel of charge air distribution pipe | Nm<br>Nm | AR01.20-P-5014-02B<br>*BA01.20-P-1002-01A<br>*BA01.20-P-1003-01A |
| 3 | Disconnect fuel lines (1, 2) at fuel full-flow filter (70) | Collect fuel which flows out.<br>Pay attention to use of locking arm. See: # Disconnecting and connecting fuel lines at engine. | AR47.25-P-1000-01A |
| 4 | Take off fuel cooler (3) | i Take off only the bolts (4) and raise fuel cooler slightly. | |
| 5 | Remove fuel full-flow filter (70) | Collect fuel which flows out.<br>**Installation:** If the fuel full-flow filter has been drained, it must be filled with fuel after being installed and before starting the engine to ensure engine starts properly.<br>Nm | *BA47.20-P-1001-02A |
| 6 | Install in the reverse order | | |

| | | | |
|---|---|---|---|
| ⚠ **Danger!** | **Risk of accident** as a result of vehicle starting off when engine running. **Risk of injury** as a result of bruises and burns if you insert your hands into engine when it is being started or when it is running. | Secure vehicle to prevent it starting off. Wear closed and close-fitting work clothes. Do not grasp hot or rotating parts. | AS00.00-Z-0005-01A |
| 7 | Run engine and inspect fuel system for leaks | | |

**Nm Crankcase ventilation, cylinder head cover**

| Number | Designation | | Engine 612.963 |
|---|---|---|---|
| BA01.20-P-1002-01A | Screw of trim panel of cylinder head cover to cylinder head cover | Nm | 10 |
| BA01.20-P-1003-01A | Screw of trim panel of charge air distribution pipe to charge air distribution pipe | Nm | 10 |

**Nm Fuel filter**

| Number | Designation | | Engine 612.961/ 963 |
|---|---|---|---|
| BA47.20-P-1001-02A | Bolt of fuel filter to charge air distribution pipe | Nm | 14 |